

Date: Wednesday, 6/6/2007 3:06:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 32831	
Estimate Number : 12825	
P.O. Number :	Part Number : D3578041
This Issue : 6/6/2007 S.O. No. :	Drawing Number : D3578 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 32483	Material :
Written By :	Due Date : 6/27/2007 Qty: 60 Um: Each
Checked & Approved By : <u>07.06.07</u>	
Comment : Est: A 07.04.11 New issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.0074 sf(s)/Unit Total: 0.4410 sf(s)

6061-T6 sheet 0.080"

(M6061T6S080)

Batch: m104392ml 07 06 10

(60)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3578 (Run prog. D3578-1)

Dwg Rev: AProg Rev: Aml 07 06 10

(60)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

ml 07 06 10

(60)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

07.06.11

(60)

Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

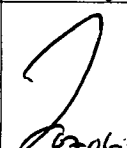
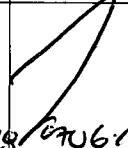


(PTD)


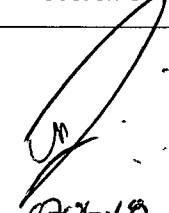

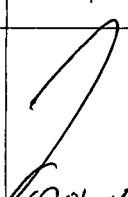
Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Open rivet holes to 0.098" and C'sink as per dwg D3578

SAD07/06/1256 PTD501QC 5En 07.06.12 (56)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-07-18	5.0	Add QCS for <del>next</del> c'sink inspection. perm. change	EC	07-06-18		 07-06-18	 07-06-18	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/18	5.0	c'sink shade is to big 4-part scrap	 QSI042	Scrap, destroy	07/06/18 SAD	 07-06-18	 07-06-18	 07-06-18

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:06:06 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 32831

Part Number: D3578041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(56X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF 07/06/19

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-06-19

8.0

MS21075L3

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)

Nutplate

Batch: m18534

9.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 120.0000 Each(s)

Rivet

m1563 -

MF 07-06-19

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per dwg D3578

MF 07-06-19

(56)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/06/20 (56)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

P 7/4/20 (56)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(56)

Comment: FINAL INSPECTION/W/O RELEASE

9 07/06/20

Job Completion



C207/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

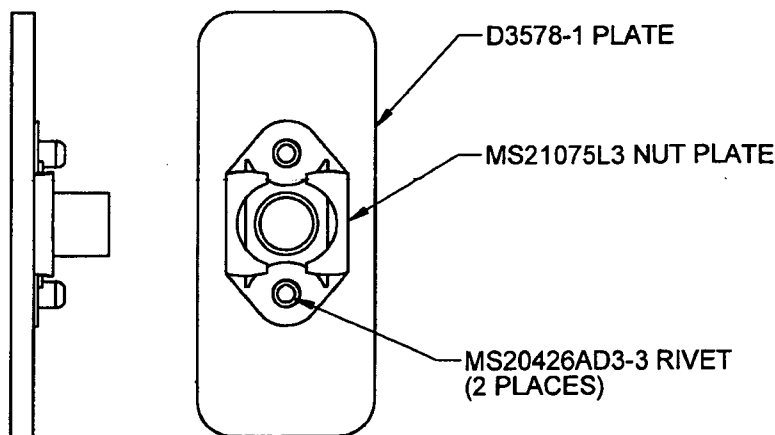
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JS</i>	APPROVED <i>JS</i>	DRAWING NO. <b>D3578</b>	REV. A SHEET 1 OF 1
DATE <b>07.01.12</b>		TITLE <b>DOUBLER</b>	SCALE 3:2
REV A	DATE 07.01.12	DESCRIPTION NEW ISSUE	



**RELEASED**  
07.04.02

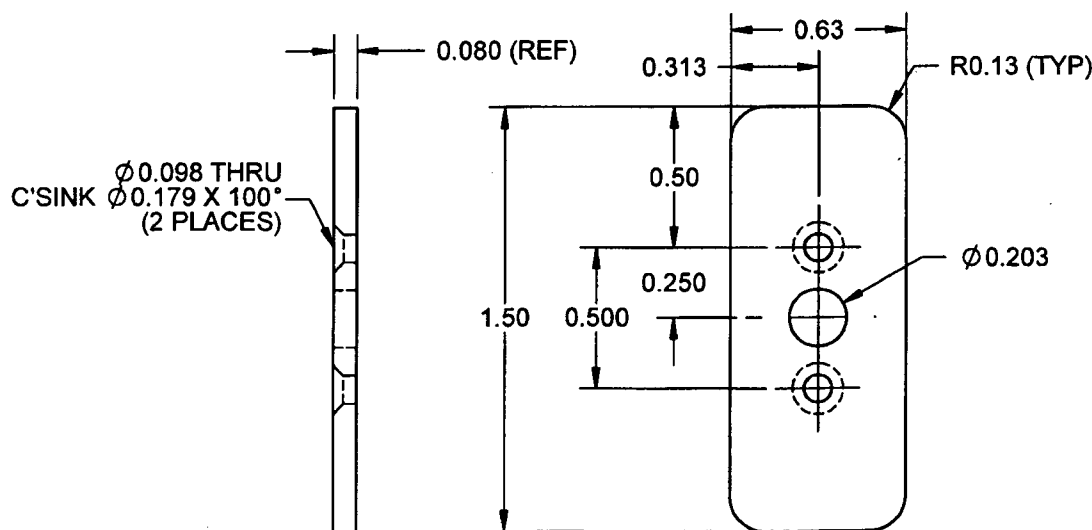
**D3578-041 PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3578-041	DOUBLER
1	D3578-1	PLATE
1	MS21075L3	NUT PLATE
2	MS20426AD3-3	RIVET

**D3578-041 DOUBLER**

**D3578-041 NOTES:**

1) IDENTIFY WITH DART P/N "D3578-041" USING FINE POINT PERMANENT INK MARKER



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 3283



**D3578-1 PLATE**

**D3578-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK PER QQ-A-250/11 OR AMS 4025 OR 4027 (REF DART SPEC M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

**COPYRIGHT © 2007 BY DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD		Work Order: 32831
Description: Doubler		Part Number: D3578-1
Inspection Dwg: D3578 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.098$	+0.004-0.001	0.098	✓		vern	
B $\phi 0.203$	+0.005-0.001	0.203	✓		vern	
C 0.63	+1-0.030	0.63	✓		vern	
D 1.50	+1-0.030	1.503	✓		vern	
E 0.500	+1-0.010	0.500	✓		vern	
F 0.50	+1-0.030	0.504	✓		vern	
G R0.13	+1-0.030	R0.13	✓		R-G	
H 0.250	+1-0.010	0.247	✓		vern	
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>mm.m</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 07 06 10	Date: 07 06 11	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	